

Work Order ID 59450

Friday, June 04, 2010 11:25:30 AM



Page 1

Item ID: D3112-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-6-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3112

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 0.625" x 1.500 bar x 2.625" long.

10/06/23

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA233 Note: Engrave / scribe DART P/N on part as per
dwg. Deburr break all unmarked sharp edges .005 to 0.010

10/06/23

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/06/23

6 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Start Date: 6/4/2010 Start Qty: 6.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|------------------|--------------|---------------|---------------|------------------|----------------|
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | mmw= 10/06/24 | | 6 | 0 | | |
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | N 10/06/24 | | XL | 6 | | |
| 150 Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 1:10 320° FINISH TIME: 1:40 | 0.00 0.00 | | | | | | | |

⑥ BL 10-6-24

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Page 3

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Revision ID:

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Item Name: Guide

Start Date: 6/4/2010 Start Qty: 6.00



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | ml | 10 | 06 | 28 (6) |
| 170 | Identify as per dwg & Stock Location: 034 | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | | | | 10/06/28 (6) |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | 10/06/29 JF MF 10-6-29 |

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:25:35 AM

Page 1

Work Order ID: 59450

Parent Item: D3112-1

Parent Item Name: Guide

Comments: IPP A ☐ 02.05.22 ☐ New Issue ☐ NG ☐

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.625X01.50 0 | | Purchased | No | | | 100 | f | 0.0000 | 0.2271 | 1.434316 | | | |



6061-T6 Bar .625 x 1.50



.750 x 1.50

For 10.06.22
This Batch
only.

B 114415 J.V. 10/06/23

1.4343 ft.

m 6061T6B0.750X01.500

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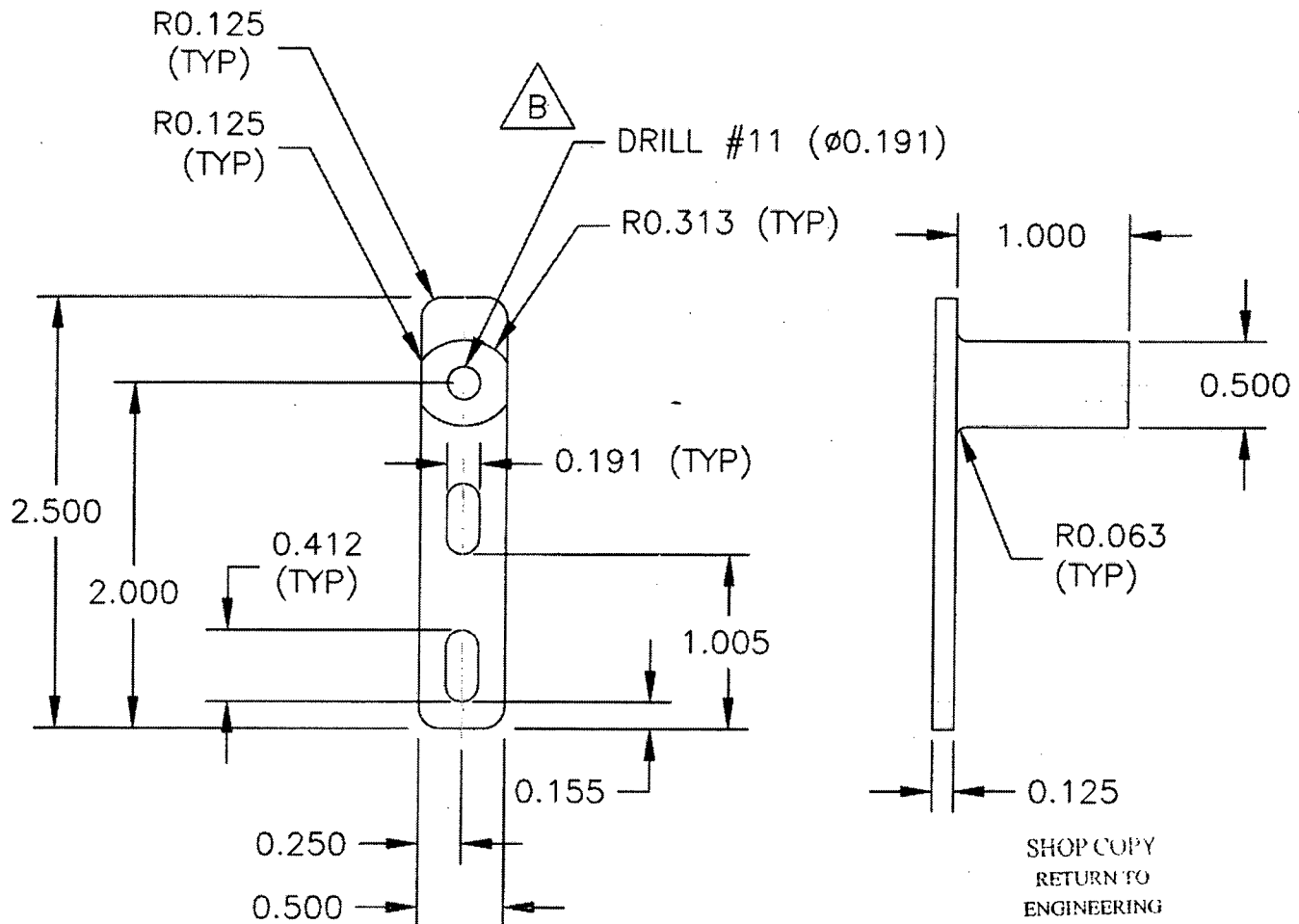
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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• NOTE: Date & initial all entries

DART

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|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3112 | REV. B SHEET 1 OF 1 |
| DATE 04.10.18 | | TITLE GUIDE | SCALE 1:1 |
| A | 02.04.12 | NEW ISSUE | |
| B | 04.10.18 | ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$ | |

RELEASED
04.11.23 #**D3112-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF
NO. 59450

10-6-09

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